Dart Aerospace Ltd. 07/03/28 Monday, 3/19/2007 4:38:53 PM Kim Johnston User **Process Sheet** : DOOR ASSEMBLY **Drawing Name** : CU-DAR001 Dart Helicopters Services Customer Job Number : 31302-2 : 11403 Estimate Number : D3296041 Part Number P.O. Number : NIA S.O. No. : 11 D3296 REV A : 3/19/2007 **Drawing Number** This Issue : N/A Project Number Prsht Rev. : MA : SMALL /MED FAB **Drawing Revision** First Issue : NIA 14 : 30608 Material Previous Run : 3/30/2007 10 Um: Due Date Written By Checked & Approved By : Est. C 05/10.14 Added step 14 KJ/EC Est Rev:D Revised Steps 06-11-20 JLM Additional Product Job Number: Description: Machine Or Operation: Seq. #: 1.0 Door Panel Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s) Door Panel Pick: Description Batch Qty Part Number Door Panel **B** 31344 D3296-1 Door Panel 2.0 D32963 Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s) Door Panel Pick: Qty Part Number Description 07-04-13 D3296-3 Door Panel D31617 3.0

Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

> Hinge 14" Batch:

Hinge 17"

D31619

Comment: Qty.:

1.0000 Each(s)/Unit Total: 10.0000 Each(s)



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Monday, 3/19/2007 4:38:53 PM Date: ' Kirn Johnston User: **Process Sheet** Drawing Name: DOOR ASSEMBLY Customer: CU-DAR001 Dart Helicopters Services Part Number: D3296041 Job Number: 31302 Job Number: Description: Seq. #: Machine Or Operation: MS20470AD44 Rivet. Universal Head 50 25.0000 Each(s)/Unit Total: 250.0000 Each(s) Comment: Qty.: Rivet, Universal Head 10 Batch: 17 103 44 SMALL & MEDIUM FAB RESOURCE 1 SMALL FAB 1 Comment: SMALL & MEDIUM FAB RESOURCE 1 07-04-17 Fabricate & assemble as per Dwg D3296. INSPECT WORK TO CURRENT STEP QC5 70 WORK TO CURRENT STEP Comment: INSPECT POWDER COATING 8.0 POWDER COATING M102316 Comment: POWDER COATING Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3 9.0 QC3 POWDER COAT/CHEMICAL CONVERSION 10.0 D2137 Decal - No Step Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s) Decal - No Step Pick: Qty Part Number Description Batch B31330 D2137 Decal 1 D2419 11.0 Comment: Qty.: 1.0000 Each(s)/Unit Total; 10.0000 Fach(s) Handle Pick: Qty Part Number Description Batch D2419 Handle

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Part No		PAR #: Fault Category:	NCR: Yes	No DQ	A:	Date:			

QA: N/C Closed: \_\_\_\_ Date: \_\_\_\_

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC		Corrective Action Section B		Verification		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approva QC Inspecto
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Monday, 3/19/2007 4:38:53 PM Date; User: Kim Johnston **Process Sheet** Drawing Name: DOOR ASSEMBLY Customer: CU-DAR001 Dart Helicopters Services Part Number: D3296041 Job Number: 31302 Job Number: Description: Seq. #: Machine Or Operation: D24620040 12.0 Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s) Seal Pick: Qty Part Number Description Batch D2462-0040 Seal D24620053 13.0 Comment: Qtv.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s) Seal Pick: Qty Part Number Description Batch Seal D2462-0053 D24620245 14.0 Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s) Seal Pick: Part Number Description Batch Qty D2462-0245 1 Seal 15.0 D27281 Dart Logo label small 1.0000 Each(s)/Unit Total: 10.0000 Each(s) Comment: Qty.: Dart Logo label small Pick: Part Number Description Batch Qty 1 D2728-1 Decal 16.0 AN960JD6 Washer Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s) Washer Pick: Qty Part Number Description AN960JD6 Washer

## Dart Aerospace Ltd

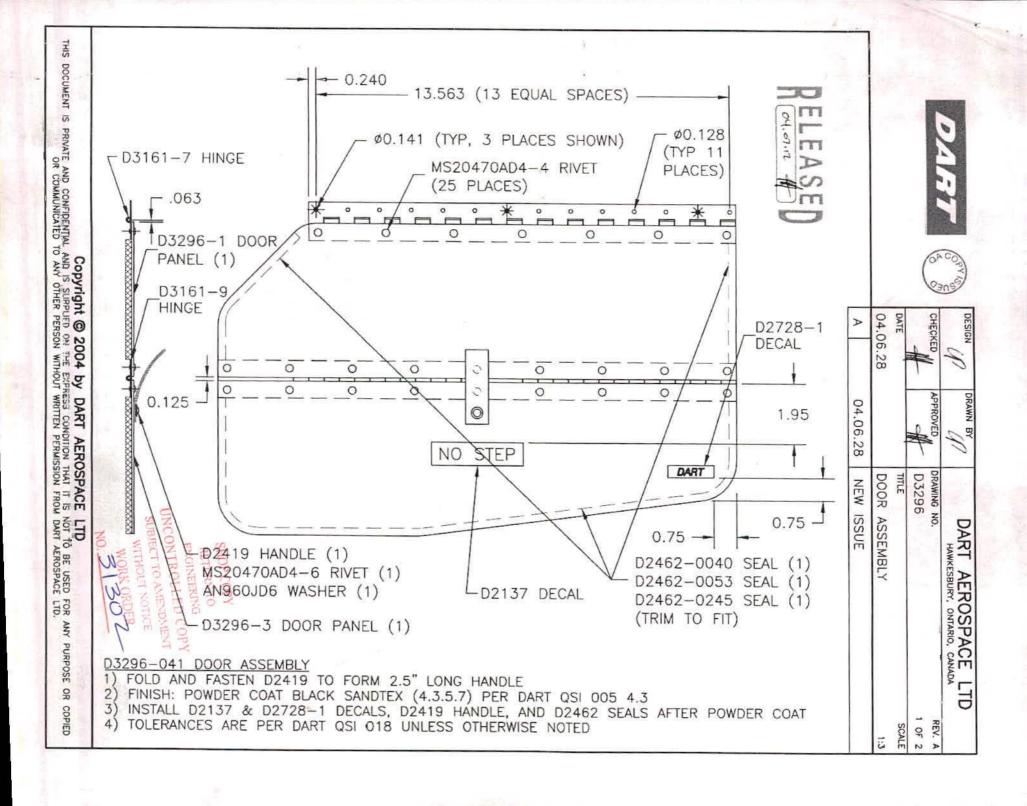
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		Description of NC		Corrective Action Section E	3	V164		
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Monday, 3/19/2007 4:38:53 PM Date: Kim Johnston User: **Process Sheet** Drawing Name: DOOR ASSEMBLY Customer: CU-DAR001 Dart Helicopters Services Part Number: D3296041 Job Number: 31302 Job Number: Description: Seq. #: Machine Or Operation: MS20470AD46 Rivet, Universal Head 17.0 Comment: Qty.: Total: 10.0000 Each(s) Rivet, Universal Head Pick: Part Number Description Batch Qty M 103691 MS20470AD4-6 Rivet SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1 18.0 Comment: SMALL & MEDIUM FAB RESOURCE 1 XIO Assemble as per Dwg D3296 INSPECT WORK TO CURRENT STEP 19.0 QC5 Comment: INSPECT WORK TO CURRENT STEP PACKAGING RESOURCE #1 20.0 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 21.0 QC21 Comment: FINAL INSPECTION/W/O RELEASE 2 Sq. 4. 24 Job Completion 

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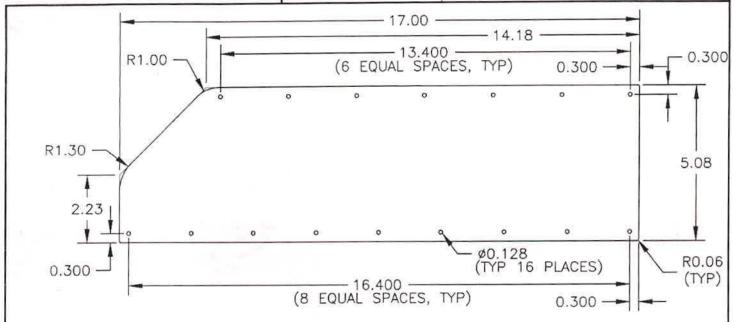
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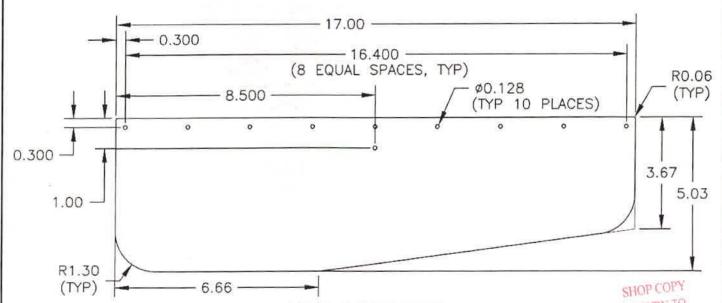




DESIGN OF	DRAWN BY	DART AEROSPA HAWKESBURY, ONTARIO,	
CHECKED	APPROVED	DRAWING NO. D3296	REV. A 2 OF 2
DATE		TITLE	SCALE
04.06.28		DOOR ASSEMBLY	1:3



## D3296-1 DOOR PANEL



## D3296-3 DOOR PANEL

D3296-1 AND D3296-3

1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK (REF DART SPEC. M2024T3S.063)

- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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